

Work Order ID 58465

May 7, 2010 10:22:11 AM



Page 1

Item ID: D4037-3

Accept



Setup Start



Revision ID:

Item Name: Fwd Crossbeam

Stop



Start Date: 07/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *R*Date: *10-5-07*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4037

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4037-3_BLANK

*B10-5-13**(4)*

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA878 AND DWG

FOLIO REV: *44*DWG REV: *13*

DEBURR

*mk 10/05/02**4 0*

Work Order ID 58465

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| | | | | | | |
|----------------|---------------|------------|------|---------------|-------|--|
| Item ID: | D4037-3 | Accept | | Setup | Start | |
| Revision ID: | | | | | | |
| Item Name: | Fwd Crossbeam | | | | Stop | |
| Start Date: | 07/05/2010 | Start Qty: | 4.00 | | | |
| Required Date: | 14/05/2010 | Req'd Qty: | 4.00 | | | |
| Reference: | | | | | | |
| | | | | Cust Item ID: | | |
| | | | | Customer: | | |

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 150 Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START: 3:15pm Temp: 320F Fru: 3:45pm | 0.00 0.00 | | | | 4 | 0 | | |
| 160 QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | | | | |
| 170 Packaging Packaging | Identify as per dwg & Stock Location: 201 Memo | 0.00 0.00 | | | | | | | |

H 10-5-26

10-5-27

Work Order ID 58465

May 7, 2010 10:22:11 AM



Page 4

Item ID: D4037-3

Accept



Setup Start



Revision ID:

Item Name: Fwd Crossbeam

Stop



Start Date: 07/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 14/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/31 *[Signature]*
MF
10-5-27

Picklist Print

May 7, 2010 10:22:15 AM

Page 1

Work Order ID: 58465



Parent Item: D4037-3



Parent Item Name: Fwd Crossbeam

Start Date: 07/05/2010

Required Date: 14/05/2010

Comments: IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC
REV:B AS PER REV B 10-04-19 JLM VERIFIED BY:EC

IPP

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| M6061T6B1.000X15.00 0 | | Purchased | No | | | 100 | f | 78.5000 | 3.9 | 15.6 | | |



6061-T6 Bar 1.00 x 15.00



10-5-13

Location

Loc Qty

Loc Code

MAT

72

114562

72

MAT07

6.5

9544

6.5

114562

④

| | | |
|------------------------------|--|----------------------|
| DART AEROSPACE LTD | | Work Order: 58465 |
| Description: FWD CROSS BEAM | | Part Number: D4037-3 |
| Inspection Dwg: D4037 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|------------|------------------|--------|--------|----------------------|----------|
| 41.66 | $\pm .030$ | 41.660 | — | | | |
| .92 | $\pm .030$ | .920 | — | | | |
| .92 | $\pm .030$ | .920 | — | | | |
| 1.75 | $\pm .010$ | 1.750 | — | | | |
| 2.125 | $\pm .010$ | 2.125 | ✓ | | | |
| Ø.316 | $\pm .006$ | Ø.318 | — | | | |
| Ø.391 | $\pm .006$ | Ø.393 | ✓ | | | |
| .28 | $\pm .030$ | .281 | — | | | |
| 1.50 | $\pm .030$ | 1.500 | — | | | |
| 7.79 | $\pm .030$ | 7.787 | — | | | |
| 2.250 | $\pm .010$ | 2.246 | ✓ | | | |
| .875 | $\pm .010$ | .875 | — | | | |
| 6.000 | $\pm .010$ | 6.997 | ✓ | | | |
| 7.75 | $\pm .030$ | 7.750 | ✓ | | | |
| 1.125 | $\pm .010$ | 1.121 | ✓ | | | |
| 9.29 | $\pm .030$ | 9.290 | ✓ | | | |
| 10.79 | $\pm .030$ | 10.788 | ✓ | | | |
| .25 | $\pm .030$ | .245 | ✓ | | | |
| R.13 | $\pm .030$ | R.110 | ✓ | | | |
| 3.00 | $\pm .030$ | 3.003 | — | | | |
| 2.00 | $\pm .030$ | 2.001 | ✓ | | | |
| .530 | $\pm .010$ | .521 | — | | | |
| 1.00 | $\pm .030$ | 1.019 | ✓ | | | |

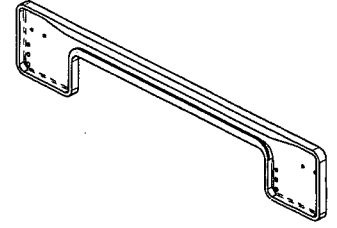
| | |
|--------------|----------|
| Measured by: | amf |
| Date: | 10/05/22 |

| | |
|-------------|----------|
| Audited by: | H.A |
| Date: | 10/05/24 |

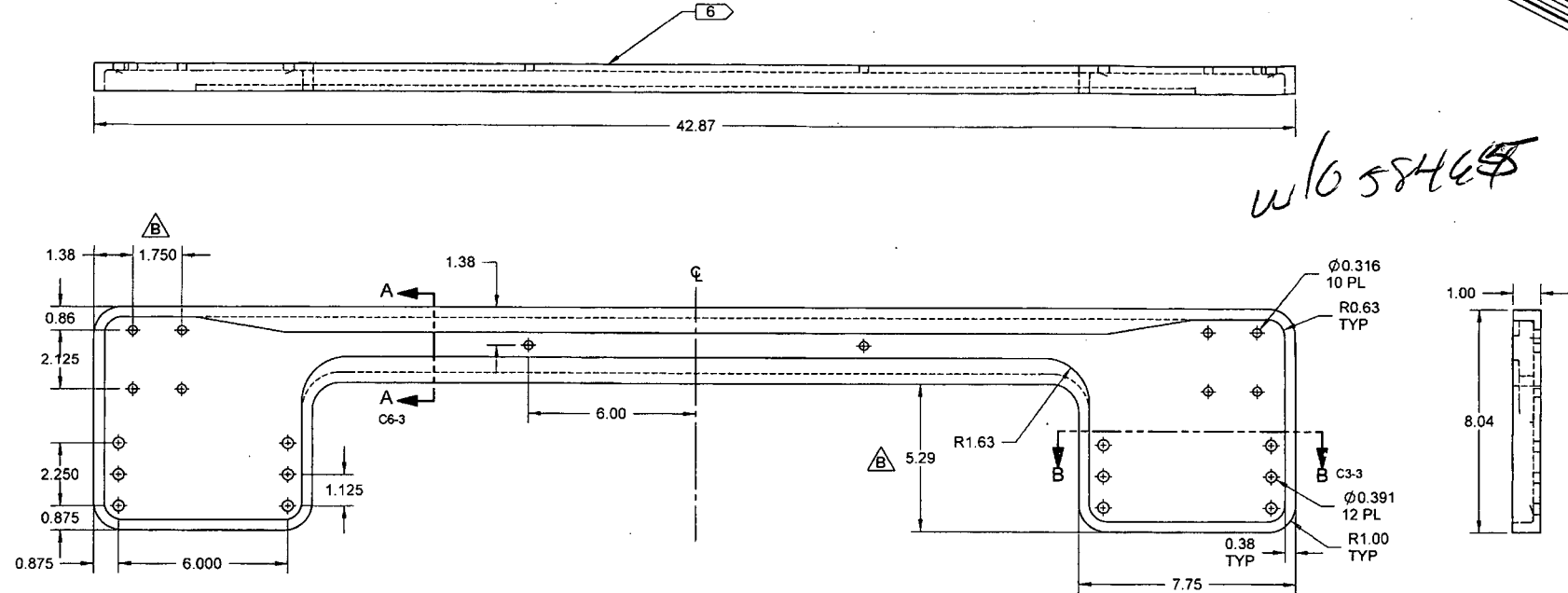
| | |
|---------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58465



W/O 58465



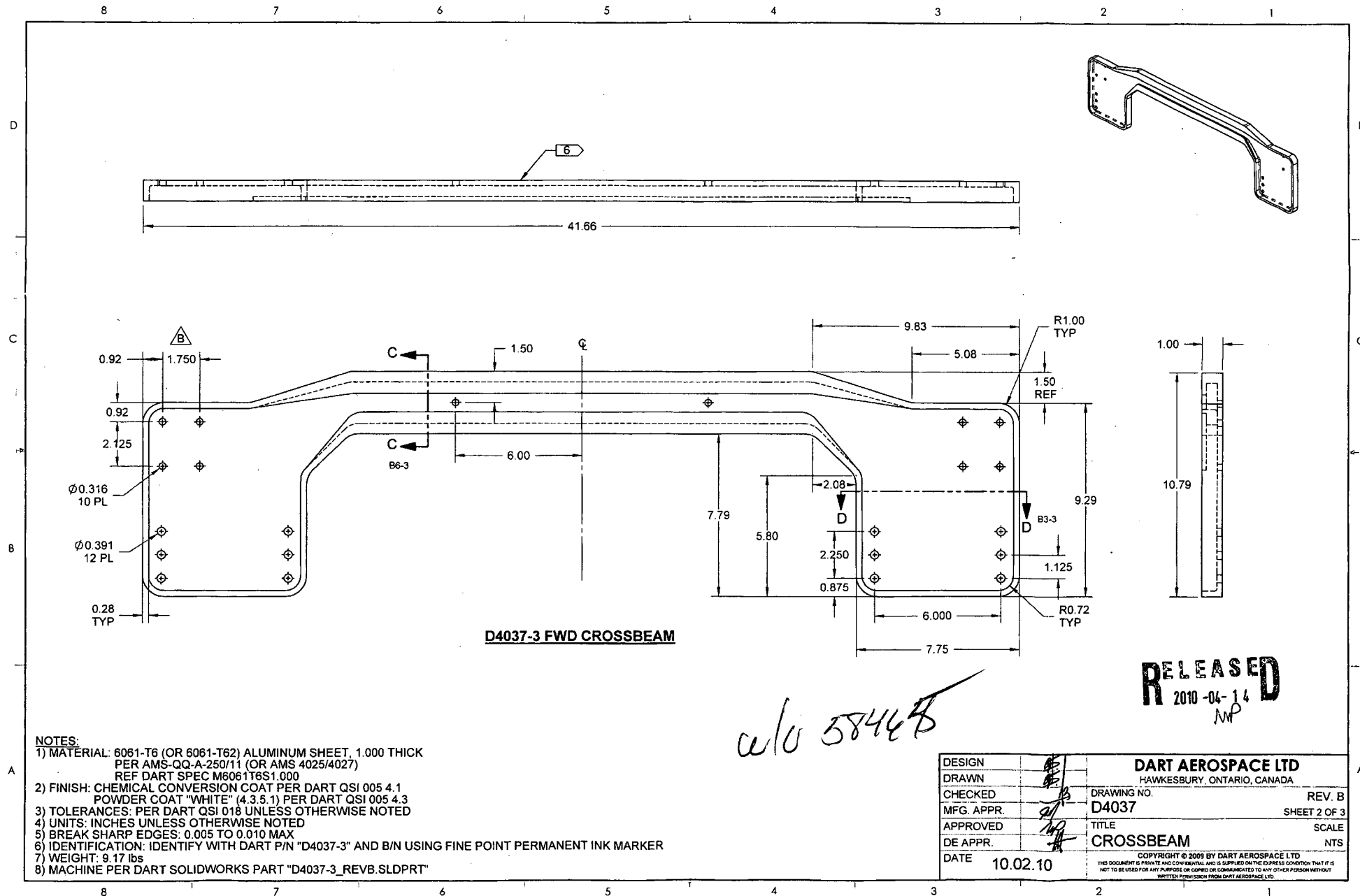
D4037-1 AFT CROSSBEAM

RELEASED
2010-04-14
WJ

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4037-1" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 8.48 lbs
 - 8) MACHINE PER DART SOLIDWORKS PART "D4037-1_REV.B.SLDPRT"

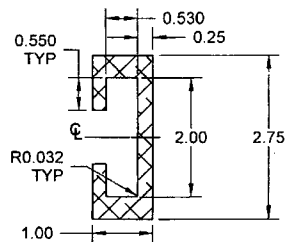
| B | ADJUST DIMS AND REPOSITION HOLES, ZN B4-1, C8-1, | HS | 10.02.10 |
|------------|--|----|----------|
| A | NEW ISSUE | HS | 09.12.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.02.10 | | |

| | |
|---|--------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D4037 | REV. B |
| TITLE CROSSBEAM | SCALE NTS |
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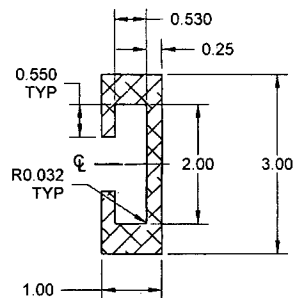


NOTES:

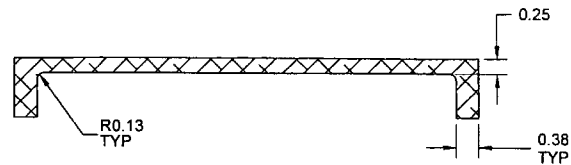
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER AMS-QQ-A-250/11 (OR AMS 4025/4027)
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4037-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 9.17 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4037-3_REV.B.SLDPRT"



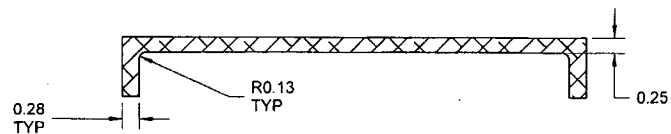
SECTION A-A B6-1
SCALE 2X



SECTION C-C B6-2
SCALE 2X



SECTION B-B B2-1
SCALE 2X



SECTION D-D B3-2
SCALE 2X

RELEASED
2010-04-16
JMP

w/o 58465

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4037 | REV. B |
| MFG. APPR. | | TITLE | SHEET 3 OF 3 |
| APPROVED | | CROSSBEAM | SCALE |
| DE APPR. | | | NTS |
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